

Work Order ID **53885**

November 23, 2009 11:22:48 AM

Page 1

Item ID: D3140-85

Accept

Revision ID: F

Item Name: Angle

Start Date: 23/11/2009 Start Qty: 10.00

Required Date: 27/11/2009 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3140

Rev F

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Cut as per dwg D3140 26.65" long ☐ Deburr. ☐ Form as per Dwg D3140 ☐ No sharp edges] ☐ Scuff surfaces with 80grit sandpaper per QSI 006 ☐ Contour as per dwg

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

8/30/12/16 (10)
8/10/04/21 (10)

(X10)

8/06/06/1

8/10/04/21

410 α

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53885



Page 2

November 23, 2009 11:22:48 AM

Item ID: D3140-85

Accept



Setup Start



Revision ID: F

Stop



Item Name: Angle

Start Date: 23/11/2009 Start Qty: 10.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10

BR/10-4-21

140

Identify as per dwg & Stock Location:

ST 176

0.00



Packaging

Memo

0.00

Packaging

m-h

10/04/26

10K

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/04/27

MF
10-4-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 11:22:56 AM

Page 1

Work Order ID: 53885

Parent Item: D3140-85RevF

Parent Item Name: Angle

Comments:

Start Date: 23/11/2009

Required Date: 27/11/2009

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	121.8000	3.6968			
5052-H32 .040 Sheet												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

121.8

101875

8.125

102723

1

104921

6.5

106900

2

107513

4.5

109058

35.675

113123

64

2509/12/16

4X
6X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO.

53885

09-11-23

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 1 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS
A	02.04.18	NEW ISSUE	
B	03.01.23	REMOVE -65/-81/-83; ADD -301/-303	
C	04.11.08	CHANGE DELASTEK SPEC. TEC-77; ADD PART MARKING; ADD NOTES 11, 12, 13; CHANGE ANGLE -95/-97/-98 TO 106°	
D	05.11.23	ADD -103/-104/-105/-106; REMOVE -67	
E	06.06.09	1.75 WAS 1.88, 4.75 WAS 4.13 ON -08/-07, 1.00 WAS 1.20 ON -09/-10	
F	06.10.06	ADD NOTE 14; CORRECT PART TITLE, NOW D3140-09/-92/-104 SHOWN D3140-10/-91/-103 OPPOSITE	

QTY -05	QTY -06	QTY -07	QTY -08	QTY -09	QTY -10	PART NUMBER	DESCRIPTION
X						D3140-05	DOOR
	X					D3140-06	DOOR
		X				D3140-07	DOOR
			X			D3140-08	DOOR
		1		X		D3140-09	DOUBLER ASSEMBLY
			1		X	D3140-10	DOUBLER ASSEMBLY
3	3					D3140-57	PAD
1	1					D3140-59	PAD
2	2					D3140-61	PAD
2	2					D3140-63	PAD
		1	1			D3140-69	PAD
		1	1			D3140-71	PAD
		1	1			D3140-73	PAD
		1	1			D3140-75	PAD
		1	1			D3140-77	PAD
		1	1			D3140-79	PAD
1	1			1	1	D3140-85	ANGLE
				1	1	D3140-87	DOUBLER
		1				D3140-89	DOUBLER
			1			D3140-91	DOUBLER
3	3					D3140-92	DOUBLER
1						D3140-95	DOUBLER
	1					D3140-97	DOUBLER
		1	1			D3140-98	DOUBLER
		2	2			D3140-99	DOUBLER
		1				D3140-101	DOUBLER
			1			D3140-103	DOUBLER
		1				D3140-104	DOUBLER
			1			D3140-105	DOUBLER
1	1					D3140-106	DOUBLER
1		1				D3140-241	DOUBLER
	1		1			D3140-301	DOUBLER
						D3140-303	DOUBLER
				5	5	MS20426AD3-4	RIVET



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111053885

DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 2 OF 7
DATE 06.10.06		TITLE DOOR	SCALE NTS

1

COMPOSITE LAYUP & BONDING I.A.W. DELASTEK PROCESS SPEC. TEC-77
MATERIAL STORAGE & HANDLING TO BE I.A.W. DART QSI 006
MAIN LAYUP USES FIBERCOTE E-761/7781 EPOXY FIBERGLASS.
FILL WITH EPOCAST 87269 OR MAGNOBOND 77 A & B AND MA560 FOAM/ NB-51/30 FOAM

2

FINISH: DUPONT HIGHBUILD GREY PRIMER 1144-S

3

MAKE PARTS IN ACCORDANCE WITH THE FOLLOWING TOOLS/MOLDS:

PART	TOOL
D3140-05	B30-23000-01T
D3140-06	B30-23000-02T
D3140-07	B30-23000-03T
D3140-08	B30-23000-04T
D3140-57	B30-23000-57T
D3140-61	B30-23000-61T
D3140-63	B30-23000-63T
D3140-69	B30-23000-69T
D3140-71	B30-23000-71T
D3140-73	B30-23000-73T
D3140-75	B30-23000-75T
D3140-77	B30-23000-77T
D3140-79	B30-23000-79T
D3140-89	D3140-89T1
D3140-301	D3140-301T1
D3140-303	D3140-303T1

RELEASED

06.11.13

4

MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK (M2024T3S.032)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

5

MATERIAL: 2024-T3 (QQ-A-250/4) 0.020 THICK (M2024T3S.020)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

6

MATERIAL: 5052-H32/H34 (QQ-A-250/8) 0.040 THICK (M5052H32S.040)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

7

MATERIAL: POLIMEX TR75 1" THICK 4.5 LB KLEGECELL

8

ALL DIMENSIONS IN INCHES

9

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

10

MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (M6061-T6S.063)
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

11

DOUBLER TO SIT ON TOP OF FOAM AT THIS LOCATION

12

DOUBLER TO BE RECESSED FLUSH INTO FOAM AT THIS LOCATION

13

RUBBER STAMP WITH DART P/N D3140-05/-06/-07/-08 USING MIL-STD-130

14

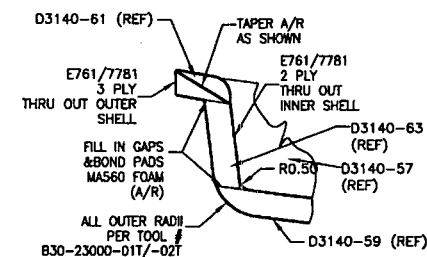
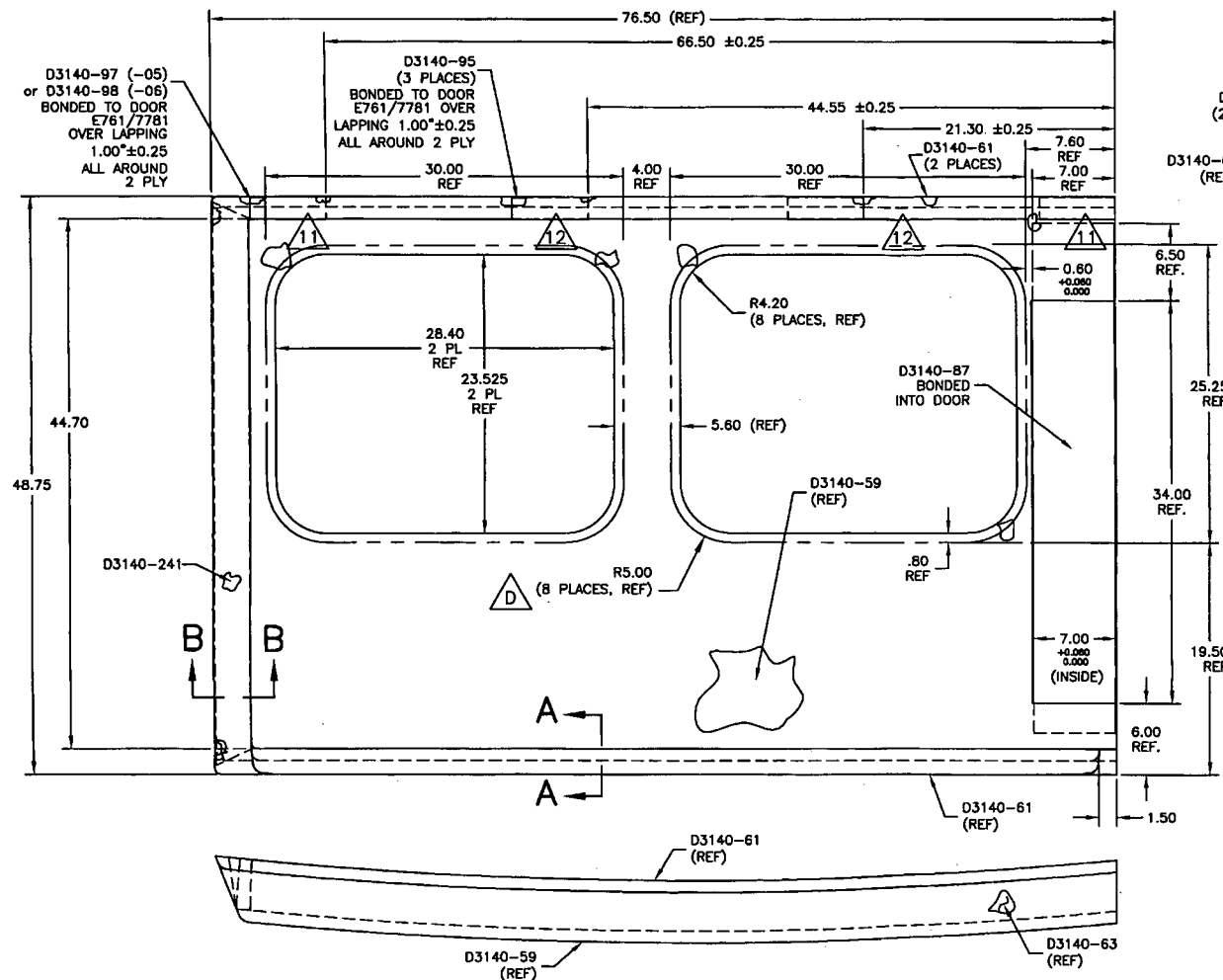
PARTS MUST BE SCUFFED WITH 80 GRIT SANDPAPER PRIOR TO ACID ETCH AND
ALODINE PER DART QSI 005 4.1



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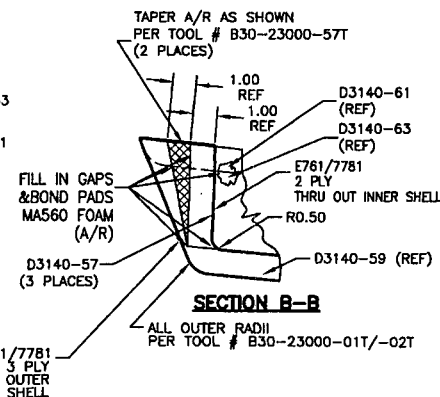
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D3140-05 DOOR (SHOWN, REPLACES PREMIER P/N B30-23000-05)
D3140-06 DOOR (OPPOSITE, REPLACES PREMIER P/N B30-23000-06)
 (WINDOWS & CUTOUTS TO BE LOCATED PER B30-23000-01T/-02T TOOL)

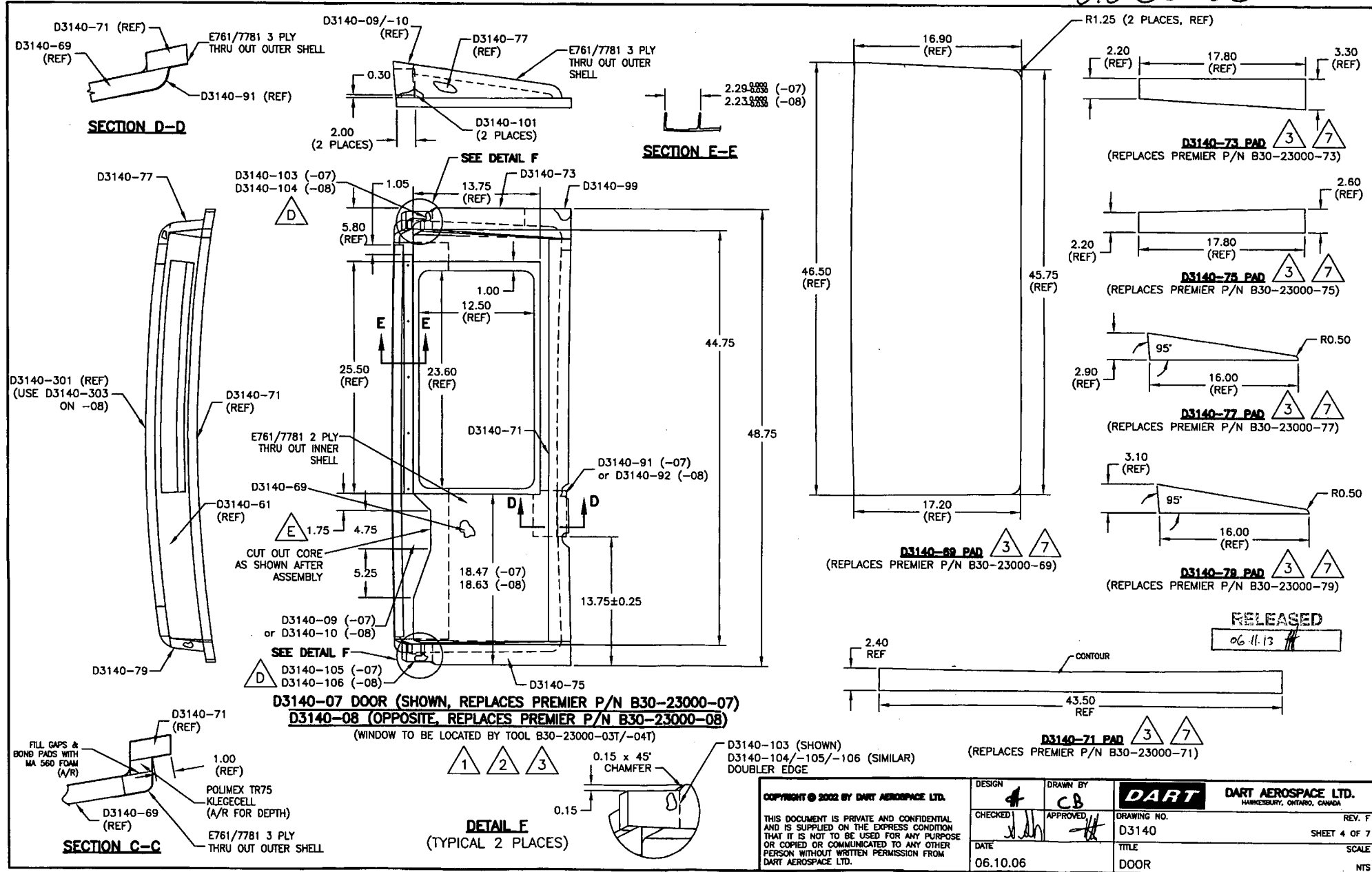


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CHECKED	[Signature]	APPROVED	[Signature]	DRAWING NO.	REV. F
DATE	06.10.06			D3140	SHEET 3 OF 7
				DOOR	SCALE
					NTS

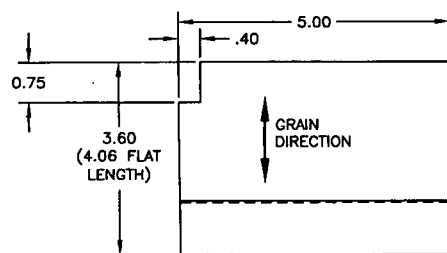
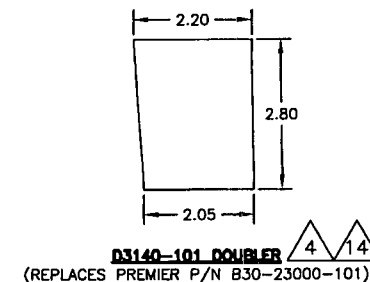
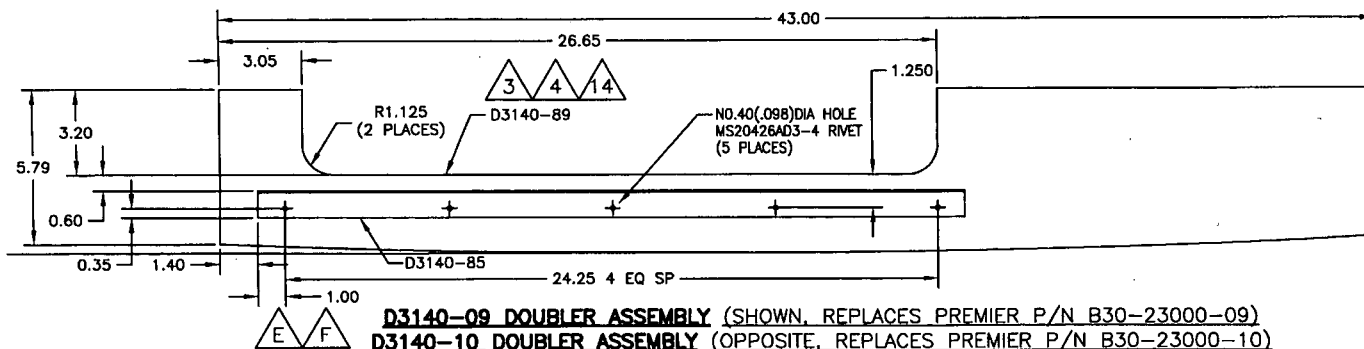
410 53885



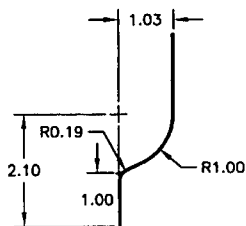
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DATE	06.10.06	TITLE	DOOR	REV. F	SHEET 4 OF 7
				SCALE	NTS

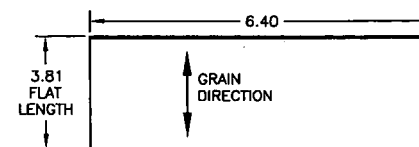
W/O 53885



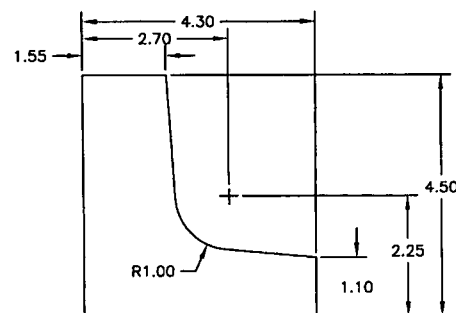
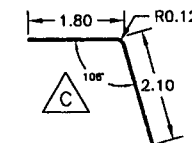
D3140-91F FLAT PATTERN
 (USE TO MAKE D3140-91/-92 DOUBLERS)



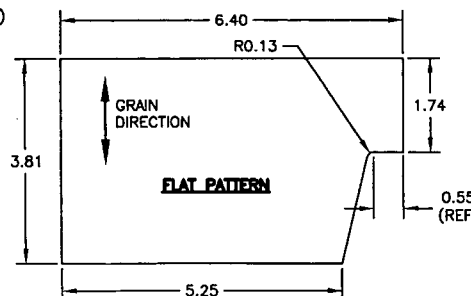
D3140-92 DOUBLER (4/14)
 (SHOWN, REPLACES PREMIER P/N B30-23000-92)
D3140-91 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-91)



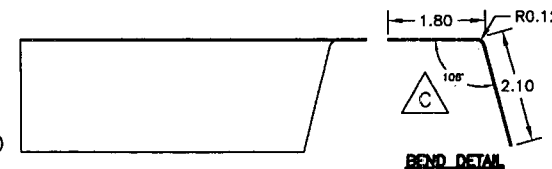
D3140-95 DOUBLER (4/14)
 (REPLACES PREMIER P/N B30-23000-95)



D3140-99 DOUBLER (4/14)
 (REPLACES PREMIER P/N B30-23000-99)



D3140-97F FLAT PATTERN
 (USE TO MAKE D3140-97/-98 DOUBLERS)



D3140-97 DOUBLER (4/14)
 (SHOWN, REPLACES PREMIER P/N B30-23000-97)
D3140-98 DOUBLER
 (OPPOSITE, REPLACES PREMIER P/N B30-23000-98)

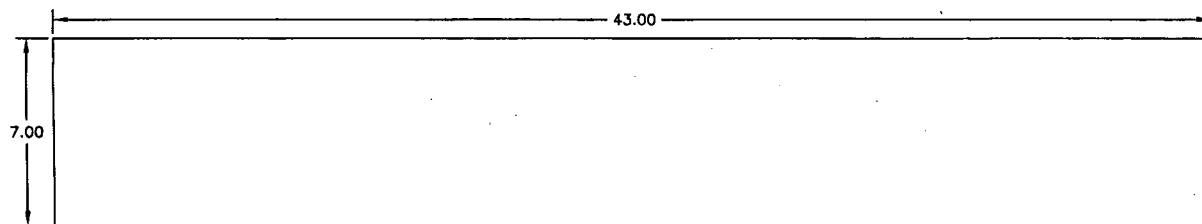
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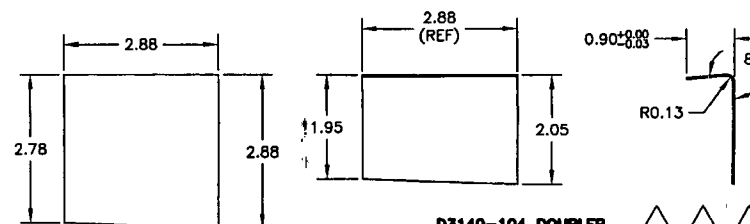
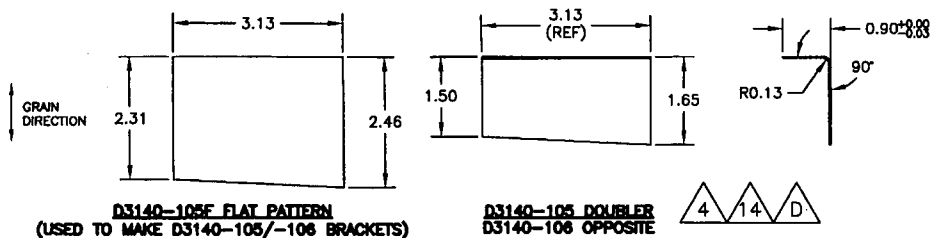
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CHECKED JAH	APPROVED #	DRAWING NO. D3140	REV. F SHEET 5 OF 7
DATE 06.10.06	TITLE DOOR	SCALE NTS	

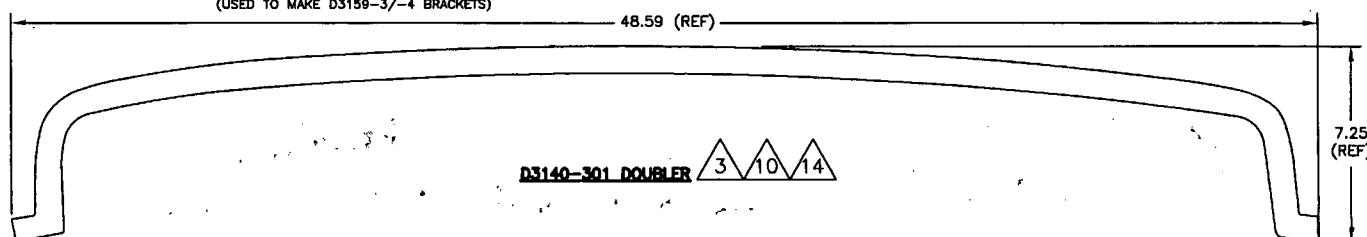
W/0 53885



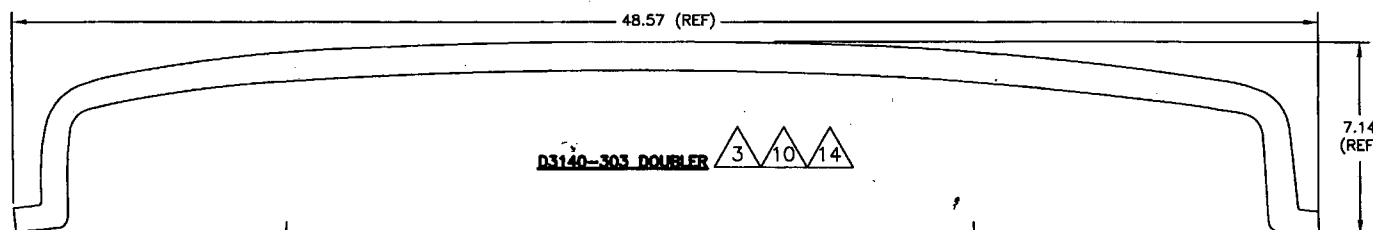
D3140-87 DOUBLER $\triangle 4 \triangle 14$
(REPLACES PREMIER P/N B30-23000-87)



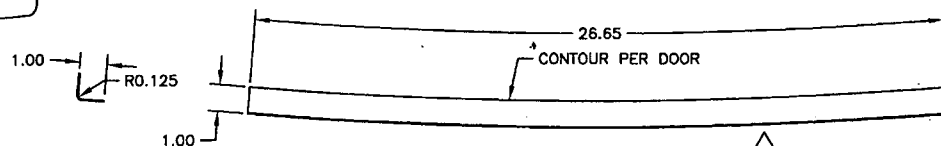
D3159-3F FLAT PATTERN
(USED TO MAKE D3159-3/-4 BRACKETS)



D3140-301 DOUBLER $\triangle 3 \triangle 10 \triangle 14$



D3140-303 DOUBLER $\triangle 3 \triangle 10 \triangle 14$



D3140-85 ANGLE $\triangle 6$
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

RELEASED

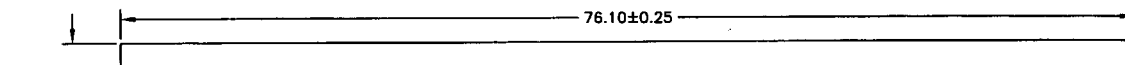
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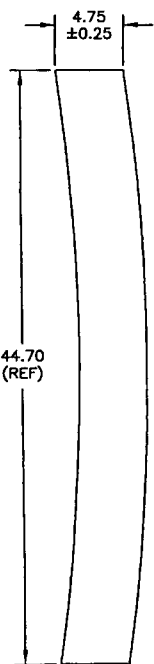
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	D3140
DATE	06.10.06	TITLE	DOOR	REV. F	SHEET 6 OF 7
				SCALE	NTS

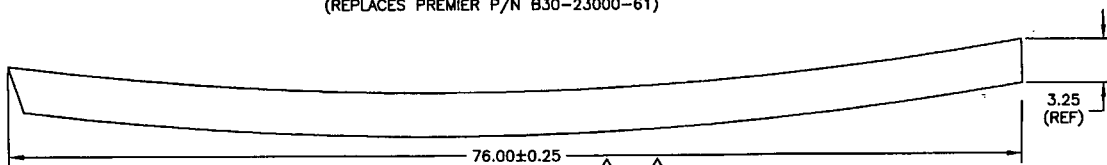
W10 53885



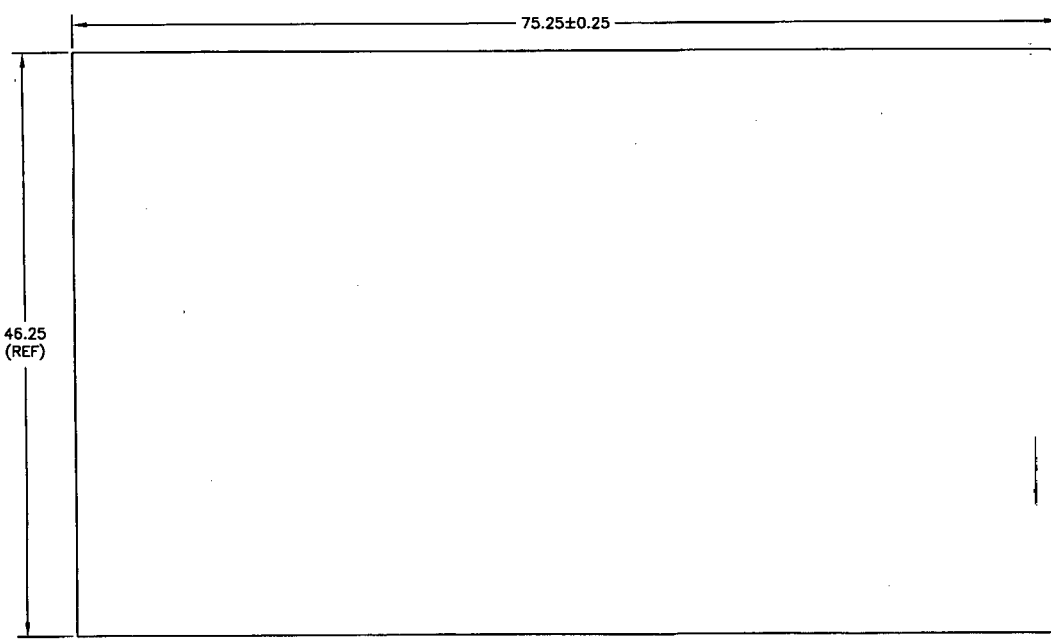
D3140-61 PAD 3 7
(REPLACES PREMIER P/N B30-23000-61)



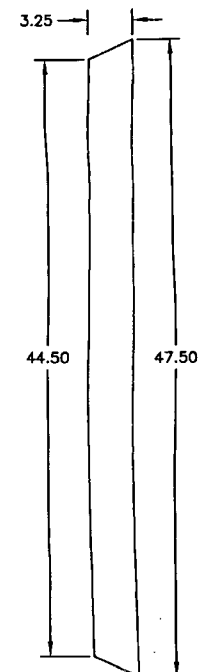
D3140-57 PAD
(REPLACES PREMIER P/N B30-23000-57)
3 7



D3140-63 PAD 3 7
(REPLACES PREMIER P/N B30-23000-63)



D3140-59 PAD 7
(REPLACES PREMIER P/N B30-23000-59)



D3140-241 DOUBLER 5 14
(REPLACES PREMIER P/N B30-23000-241)

R1.00
(2 PLACES, REF)

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		DATE 06.10.06		TITLE DOOR	SCALE NTS